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ABSTRACT

A method of producing cast steel strip having low surface roughness and low porosity by casting with molten steel having a total oxygen content of at least about 70 ppm and a free oxygen content between 20 and 60 ppm, and a temperature that allows a majority of any oxide inclusions to be in a liquidus state. The total oxygen content may be at least 100 ppm and the the free oxygen content between 30 and 50 ppm. The steel strip produced by the method may have a per unit area density of at least about 120 oxide inclusions per square millimeter to a depth of about 2 microns from the strip surface.